

Work Order ID 82249

March-27-12 2:39:46 PM

82249

Page 1

Item ID: D3564-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 27/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 10/04/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/27 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3564	Rev D

100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3564 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-								
<u>304-065</u>	Deburr if necessary								

B12-3-09

02

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B12-3-09

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

5211102

conts
722

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8179	0.00 0.00				(22)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/26/03		(22)			
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 8:00 OVEN TEMPERATURE: 320°F FINISH TIME: 8:30	0.00 0.00				22		DP	12/04/05

m117 338

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00

160

QC

Memo

0.00

Quality Control

22x2 m/12/04/05

170 Identify as per dwg & Stock Location: FP2 0.00

170

Packaging

Memo

0.00

Packaging

22 DP 12/07/05

180 QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

12/4/5

12-04-8

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Picklist Print

March-27-12 2:39:51 PM

Page 1

Work Order ID: 82249

82249

Parent Item: D3564-13

D3564-13

Parent Item Name: Wearshoe

Start Date: 27/03/2012

Required Date: 10/04/2012

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A New Issue 07-03-08 ec

IPP Rev:B As per Rev C 07-07-09 JLM

IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

IPP Rev:D Comments revised on Step 5, 6 per B44657 09-02-04 KJ

Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	343.6860	0.222	3.738947			

M304S16GA

304/316 Sheet .063

**

B12-3-29

Location

MAT020

120866

120877

121070

Loc Qty

343.686

48.18

146.506

149

Loc Code

121070

28

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Dart Aerospace Ltd

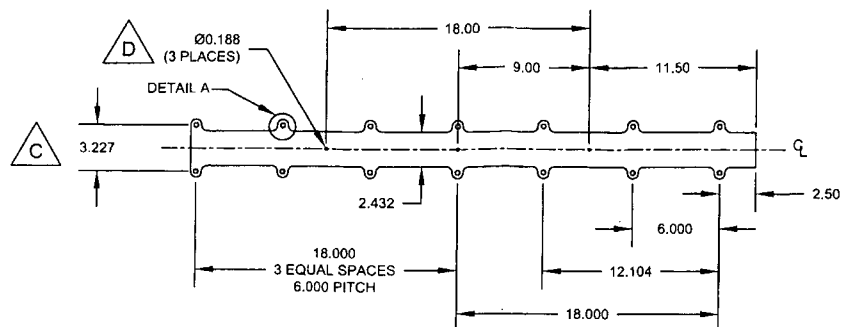
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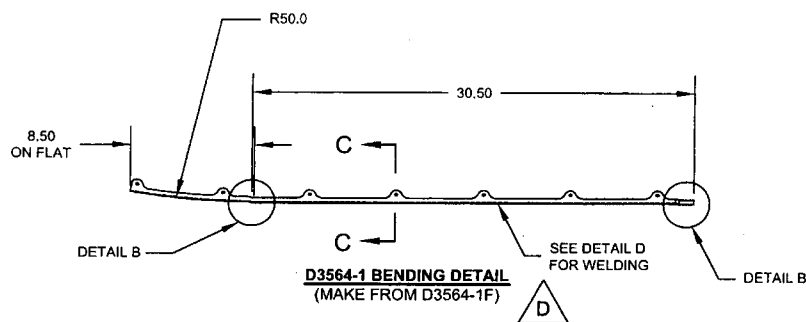
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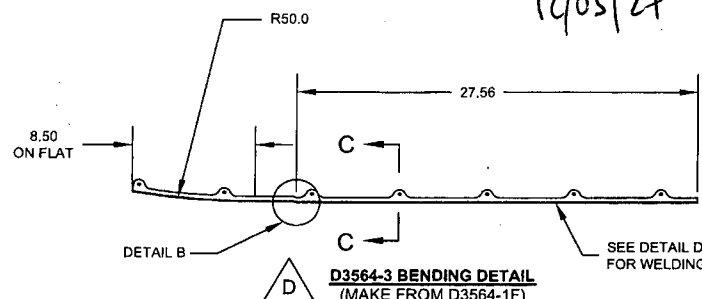
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \bar{C}

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82249 MW
1403/27

RELEASED

07.09.04

UNDER REVIEW
First change
OK 11.11.28

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8; UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3564** REV. **D**
SHEET 1 OF 3
TITLE **WEARSHOE** SCALE **1:8**

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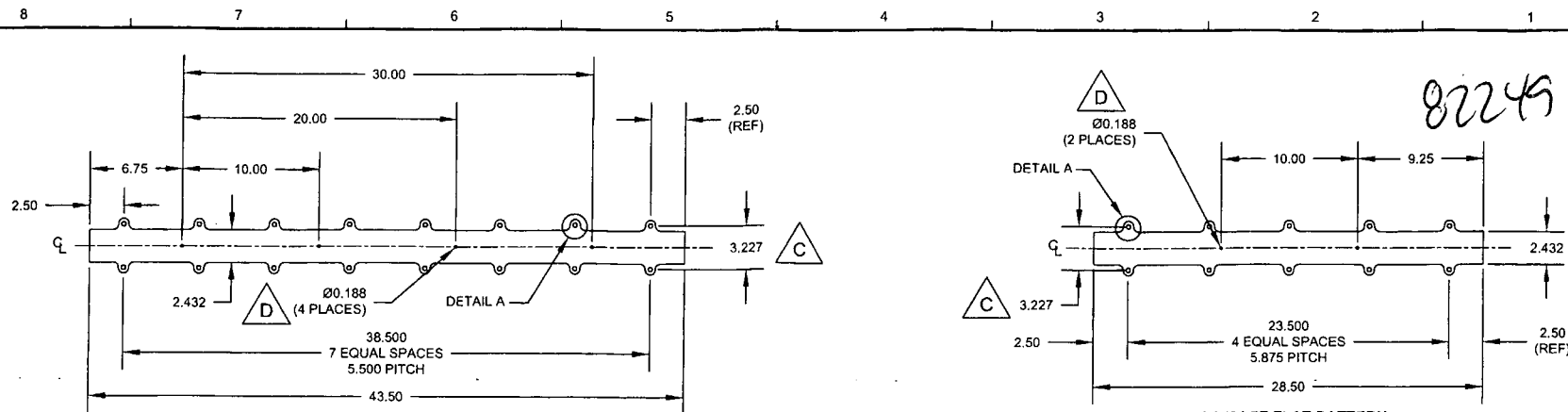
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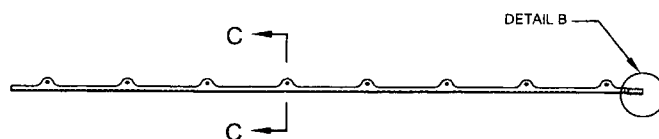
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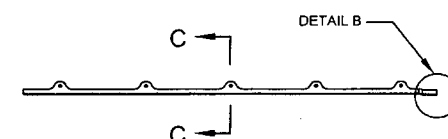


D3564-5F FLAT PATTERN

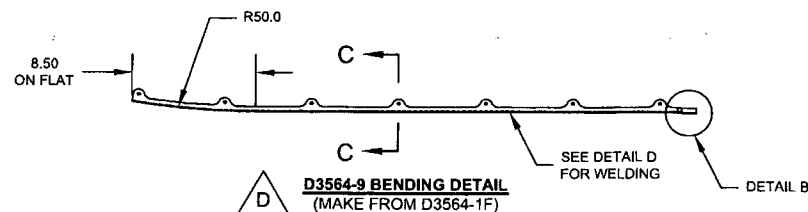
D3564-7F FLAT PATTERN



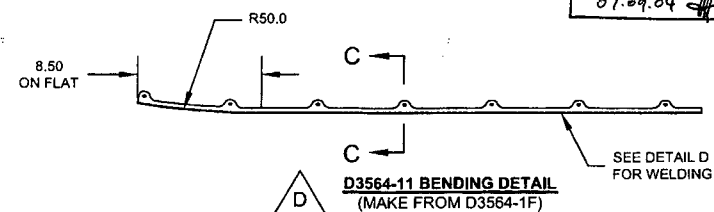
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

UNDER REVIEW
OK 07.11.28

RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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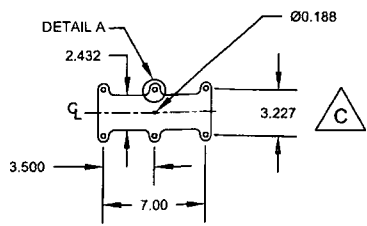
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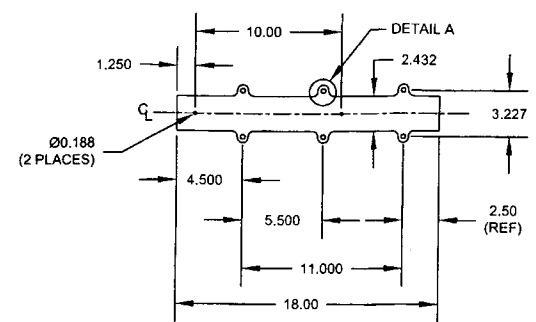
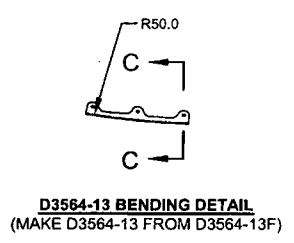
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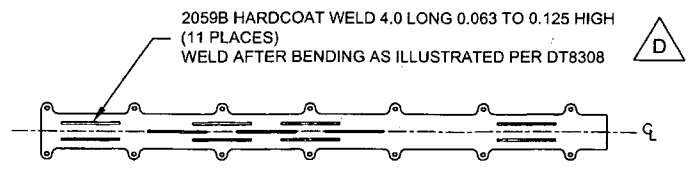
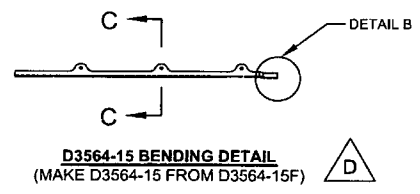
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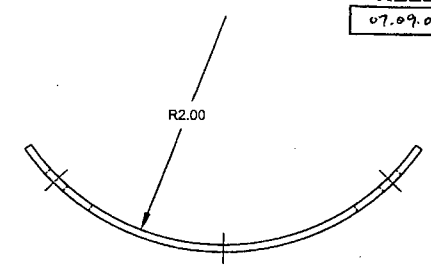
D3564-13F FLAT PATTERN



D3564-15F FLAT PATTERN

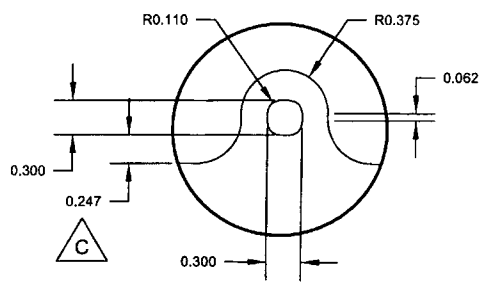


2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

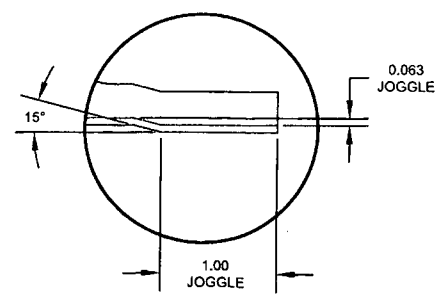


SECTION C-C
SCALE 1:1

RELEASED
07.09.04



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

UNDER REVIEW
OK 11.12.8

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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